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मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

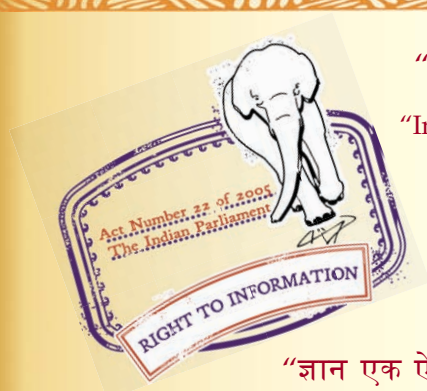
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“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

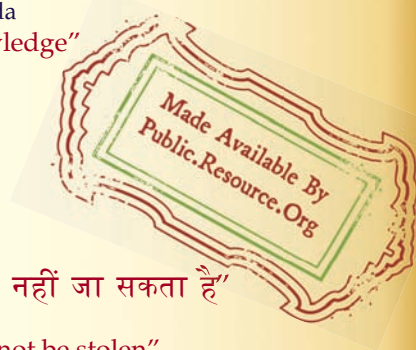
IS 4587 (1968): Raspatories, Cleft Palate, for Plastic Surgery [MHD 1: Surgical Instruments]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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IS : 4587 - 1968

(Reaffirmed 2001)

Edition 1.1

(1975-07)

Indian Standard

**SPECIFICATION FOR
RASPATORIES, CLEFT PALATE, FOR
PLASTIC SURGERY**

(Incorporating Amendment No. 1)

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

Price Group 3

Indian Standard

SPECIFICATION FOR RASPATORIES, CLEFT PALATE, FOR PLASTIC SURGERY

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Indian Standard

SPECIFICATION FOR RASPATORIES, CLEFT PALATE, FOR PLASTIC SURGERY

0. FOREWORD

0.1 This Indian Standard was adopted by the Indian Standards Institution on 23 April 1968, after the draft finalized by the Surgical Instruments Sectional Committee had been approved by the Consumer Products Division Council.

0.2 The formulation of Indian Standards on surgical instruments has been taken up at the instance of the Advisory Committee for Development of Surgical Instruments, Equipment and Appliances, Government of India.

0.3 This standard is one of a series of Indian Standards on surgical instruments. Other standards published so far in the series appear on fourth cover page.

0.4 This edition 1.1 incorporates Amendment No. 1 (July 1975). Side bar indicates modification of the text as the result of incorporation of the amendment.

0.5 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS : 2-1960*. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1. SCOPE

1.1 This standard covers the requirements for material, shape, dimensions, workmanship, finish and tests in respect of cleft palate raspatories, curved-right, curved-left, straight (two patterns each) and McIndoe's double-ended.

2. MATERIAL

2.1 McIndoe's double-ended raspatories and the blades of the other raspatories shall be made from stainless steel conforming to Designation 30Cr13 of Schedule V of IS : 1570-1961† or from carbon steel having the composition as specified in **2.2** of IS : 3318-1965‡.

*Rules for rounding off numerical values (*revised*).

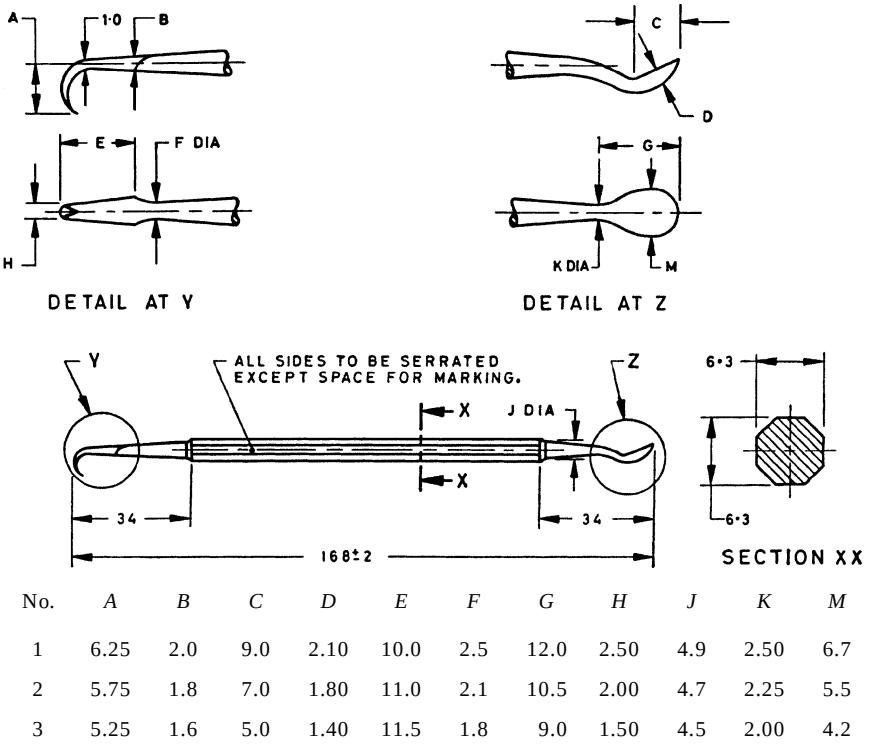
†Schedules for wrought steels for general Engineering purposes.

‡General requirements for surgical scalpels and knives.

2.2 The handles of the raspatories, other than the McIndoe's double-ended shall be pressure die-cast hollow from aluminium alloy conforming to Designation A-18 of IS : 617-1959* or shall be made from brass sheet or stainless steel sheet. The stainless steel sheet may be of the same material as used for blade.

3. SHAPES AND DIMENSIONS

3.1 The raspatories shall generally conform to shapes and dimensions as given in Fig. 1 to 7.



All dimensions in millimetres.

FIG. 1 RASPATORIES, MCINDOE'S DOUBLE-ENDED

*Specification for aluminium and aluminium alloy ingots and castings for general engineering purposes (revised).

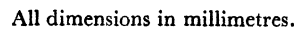
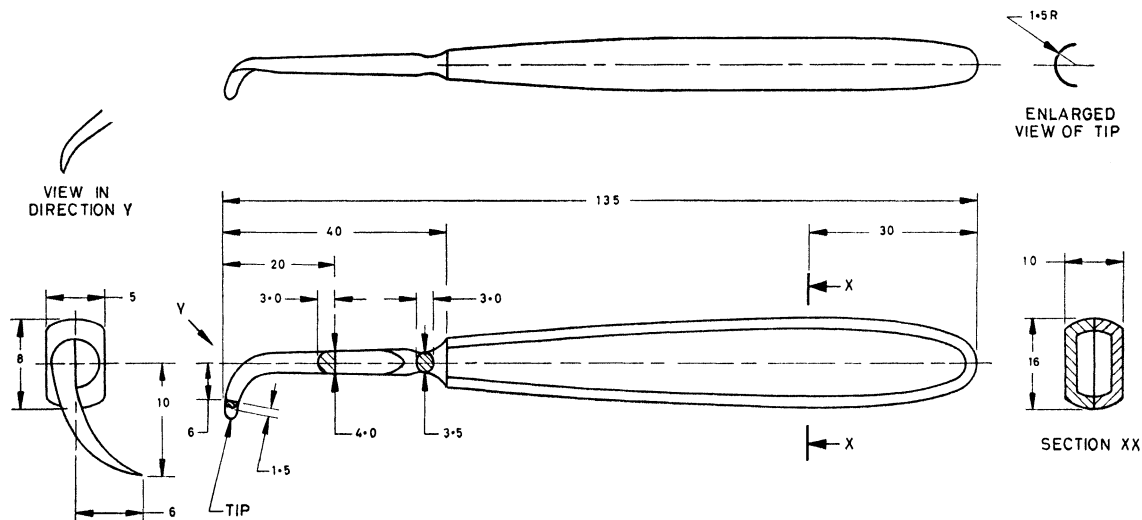
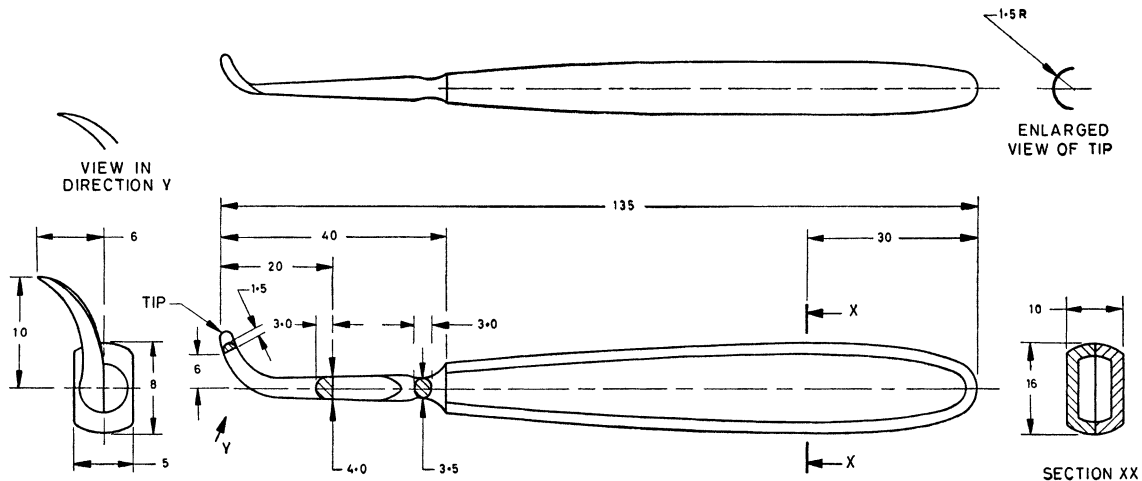


FIG. 2 RASPIATORY, CLEFT PALATE, LEFT, CURVED UP



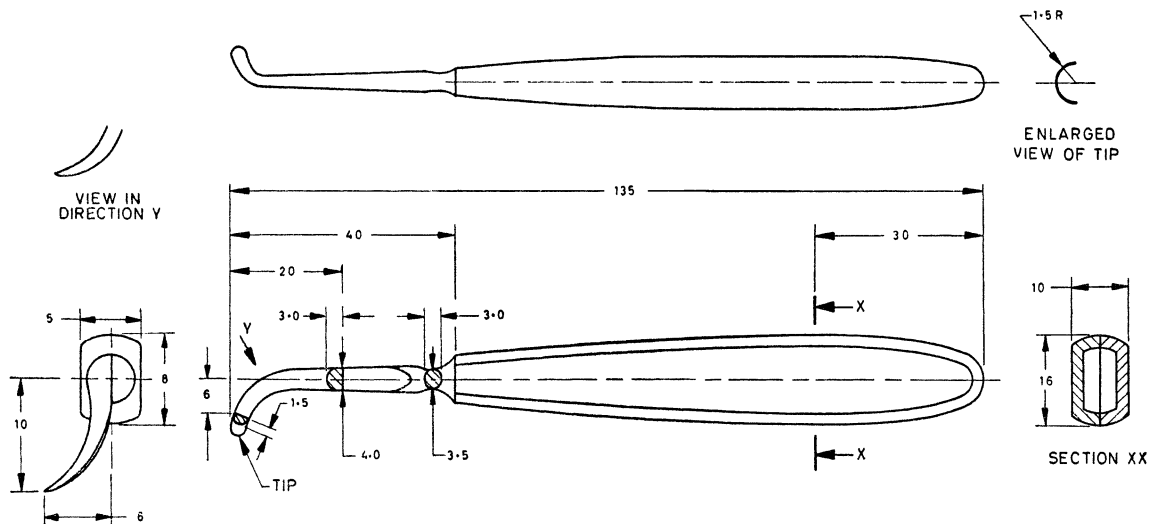
All dimensions in millimetres.

FIG. 3 RASPATORY, CLEFT PALATE, RIGHT, CURVED UP



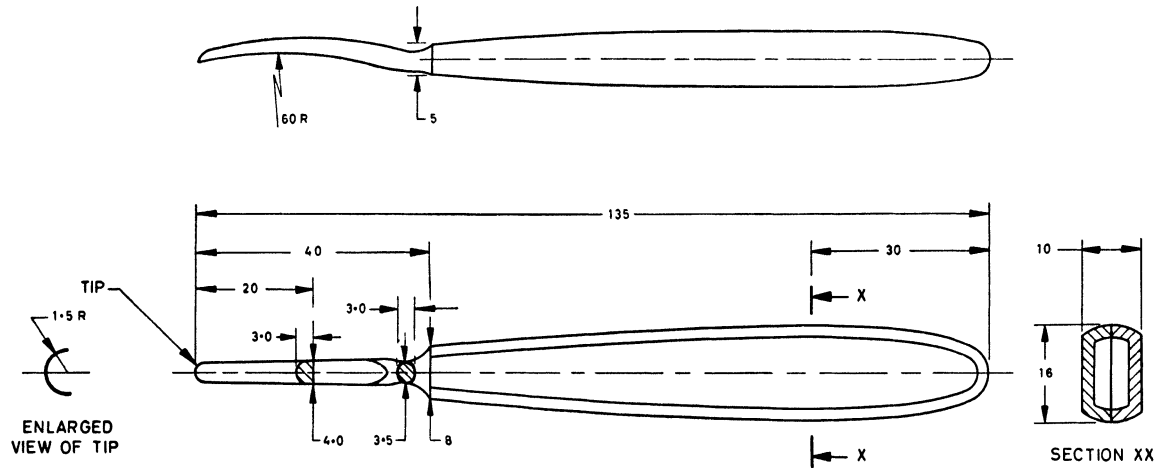
All dimensions in millimetres.

FIG. 4 RASPATORY, CLEFT PALATE, LEFT, CURVED DOWN



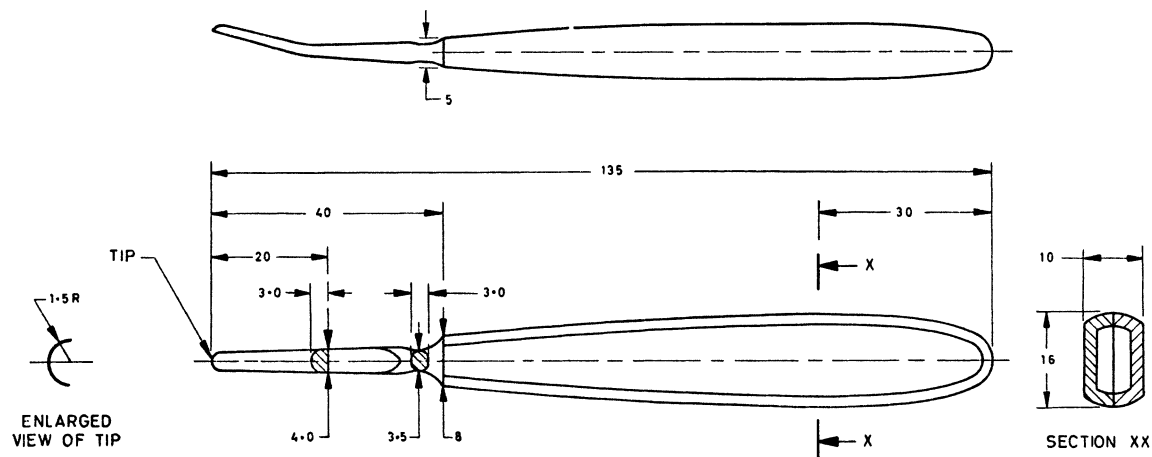
All dimensions in millimetres.

FIG. 5 RASPATORY, CLEFT PALATE, RIGHT, CURVED DOWN



All dimensions in millimetres.

FIG. 6 RASPATORY, CLEFT PALATE, STRAIGHT, CURVED UP

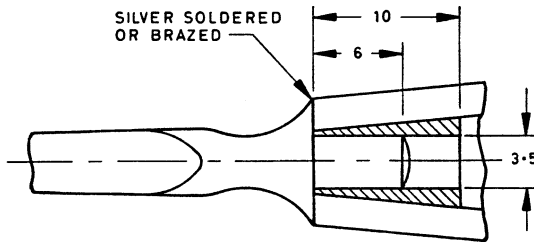


All dimensions in millimetres.

FIG. 7 RASPATORY, CLEFT PALATE, STRAIGHT, CURVED DOWN

4. WORKMANSHIP AND FINISH

4.1 The McIndoe's double-ended raspatories and the blades of the other raspatories shall be forged in one-piece with their ends well drawn and shaped. The hook ends of the McIndoe's raspatories shall be sharp and pointed. The McIndoe's double-ended raspatories shall be symmetrical on its central axis. For raspatories other than McIndoe's, the blade shall be fitted to the handle by pushfitting and brazing or silver soldering (see Fig. 8). All instruments shall be well-balanced. The instruments shall be free from burrs, pits, seams and other surface flaws. All sharp edges, except the scraping ends shall be rounded off. The scraping ends shall be even and semi-sharp. The stainless steel parts of all raspatories shall be passivated and polished bright. The McIndoe's raspatory, when made of carbon steel, shall have its handle plated chromium over nickel. The handles of other raspatories, when made from brass, shall also be plated chromium over nickel. The plating shall conform to Grade B of IS : 1068-1958*.



All dimensions in millimetres.

FIG. 8 DETAIL FOR FIXING THE BLADE TO THE HANDLE

5. HEAT TREATMENT

5.1 The raspatories shall be hardened and tempered to give a uniform hardness of 430 to 490 *HV* at the scraping ends of the blade.

6. MARKING

6.1 Each raspatory shall be clearly and indelibly marked with the manufacturer's name, initials, or trade-mark. In case of instruments or components made of stainless steel, the words 'STAINLESS STEEL' shall also be marked on the instrument or component.

6.1.1 The raspatories may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act, and the Rules and Regulations made thereunder. Presence of this mark on products covered by an Indian

*Specification for copper, nickel and chromium electroplated coatings.

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Standard conveys the assurance that they have been produced to comply with the requirements of that standard, under a well-defined system of inspection, testing and quality control during production. This system, which is devised and supervised by ISI and operated by the producer, has the further safeguard that the products as actually marketed are continuously checked by ISI for conformity to the standard. Details of conditions, under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

7. TESTS

7.1 View Under Magnification — The working ends of all raspatories shall be examined under a magnification of X 10. The scraping edges and sharp points shall be well defined and free from defects under magnification.

7.2 Performance — The scraping edges of the raspatory shall be applied to the surface of a piece of fresh bone and rubbed vigorously, to and fro, for one and a half minute. On completion of the test, the raspatory shall show no sign of damage.

7.3 The McIndoe's double-ended raspatories shall be held at the middle in a suitable vice so that each end protrudes outside the vice in the horizontal plane. A pull of 1 kgf shall be applied at the tip of the hook in a direction opposite to the curvature of the hook for two or three seconds. On completion of the test, the hook shall show no sign of damage.

7.3.1 The above test method shall also be applied to raspatories other than McIndoe's double-ended. In this case, the raspatories shall be held in vice jaws at the handles and the entire blade shall protrude beyond the jaws of the vice.

7.4 Corrosion Resistance — The instrument shall satisfy the boiling and autoclaving test as mentioned in IS : 7531-1975*.

8. PACKING

8.1 Each raspatory shall be wrapped in moisture-proof polyethylene bag and packed in cartons in a manner that coming into contact with one another is avoided.

*Method for boiling and autoclaving test for corrosion resistance of stainless steel surgical instruments.

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BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002.
Telephones: 323 01 31, 323 33 75, 323 94 02

Telegrams: Manaksanstha
(Common to all offices)

Regional Offices:		Telephone
Central	: Manak Bhavan, 9 Bahadur Shah Zafar Marg NEW DELHI 110002	{ 323 76 17 323 38 41
Eastern	: 1/14 C. I. T. Scheme VII M, V. I. P. Road, Kankurgachi KOLKATA 700054	{ 337 84 99, 337 85 61 337 86 26, 337 91 20
Northern	: SCO 335-336, Sector 34-A, CHANDIGARH 160022	{ 60 38 43 60 20 25
Southern	: C. I. T. Campus, IV Cross Road, CHENNAI 600113	{ 235 02 16, 235 04 42 235 15 19, 235 23 15
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